DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027011
Date Inspected: 10-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name: See below

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS

Summary of Items Observed:
12W-pp114-W3-1

The Caltrans Quality Assurance(QA) Inspector Rick Bettencourt randomly observed the ABF welder identified as Todd Jackson and ABF helper begin fitting up the lifting lug deck insert identified above. The QA Inspector noted the direction of rolling was stamped with a low stress stamp in the center of the insert plate, so no grinding or welding would mask or deface the identifying marking. The QA Inspector randomly observed the bevel angle to be 45°. The QA Inspector noted the surface of the bevel appeared to be a machined surface with bright shiny metal. The QA Inspector noted the ABF welder was utilizing a prefabricated round copper backing plate held in place with magnets. The QA Inspector noted the fit up was completed on the QA Inspectors shift and appeared to be in general compliance with the contract documents. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Salvador Moreno inspect and accept the fit up prior to production welding. The QA Inspector randomly observed the ABF welder begin the SMAW root pass. The QA Inspector randomly observed the SMAW parameters were 1/8” E7018 low hydrogen electrodes with 118 Amps for the root pass. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1050A-cu. After the SMAW root pass was completed the QA Inspector randomly observed the welder switch to 5/32” E7018 low hydrogen electrodes with 185 Amps and used through the completion of the weld. The QA Inspector randomly observed the ABF welder did not complete the above identified lifting lug hole on the QA Inspectors shift.

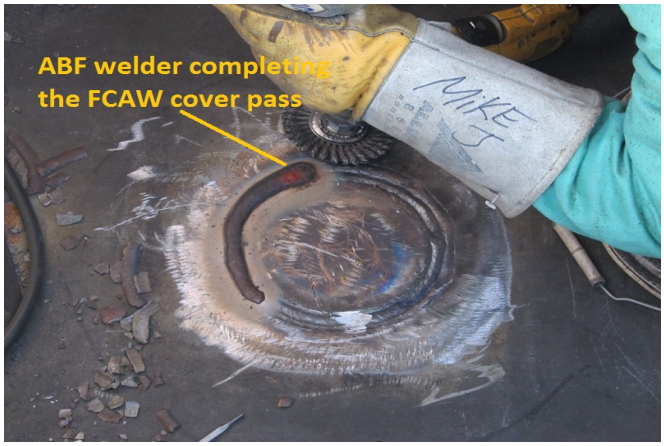
12W-pp111-W4-1

The Caltrans QA Inspector Rick Bettencourt randomly observed the ABF welder identified as Mike Jiminez and

ABF helper begin fitting up the lifting lug deck insert identified above. The QA Inspector noted the direction of rolling was stamped with a low stress stamp in the center of the insert plate, so no grinding or welding would mask or deface the identifying marking. The QA Inspector randomly observed the bevel angle to be 45°. The QA Inspector noted the surface of the bevel appeared to be a machined surface with bright shiny metal. The QA Inspector noted the ABF welder was utilizing a prefabricated round copper backing plate held in place with magnets. The QA Inspector noted the fit up was completed on the QA Inspectors shift and appeared to be in general compliance with the contract documents. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Salvador Moreno inspect and accept the fit up prior to production welding. The QA Inspector randomly observed the ABF welder begin the SMAW root pass. The QA Inspector randomly observed the SMAW parameters were 1/8” E7018 low hydrogen electrodes with 122 Amps for the root pass. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1050A-cu. After the SMAW root pass was completed the QA Inspector randomly observed the welder switch to 5/32” E7018 low hydrogen electrodes with 194 Amps and used through the completion of the weld. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on the QA Inspectors shift. The QA Inspector randomly observed and noted the weld reinforcement was not ground flush on this date.

Hinge B expansion Joint CCO-193

The QA Inspector randomly observed the ABF welders had completed the demolition of the bike path. The QA Inspector noted the ABF welder Jason Collins was performing grinding tasks of the beveled edges of the partial joint penetration of joint detail F. The QA Inspector noted the ABF welders had began the initial fit up of the end plate for detail F. After the initial fit up was completed, it was noted by the QA Inspector additional grinding would need to be completed. The QA Inspector noted no welding was performed on this date.



Summary of Conversations:

As a courtesy the QA Inspector asked the QC Inspector John Pagliero to perform UT of an area that was previously accepted by him. Mr. Pagliero performed the additional UT at the request of the QA Inspector. Mr. Pagliero informed the QA Inspector he was able to reproduce the same rejectable indication located by the QA Inspector. The QC Inspector informed the QA inspector he would reject the weld and have the area excavated and repaired.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer